106737

Page

September-11-13	3 11:35:07 A	<i>M</i> (4.35 1.5)		1 1 10	n / .s /	·						1 age	-
Item ID: Revision ID:	D3913-041			Accept	*N900	04 0	100)*	Setup		14.	S1 *	j
Item Name:	Long Basket B	Base Assemby, 350								Stop	*N.	32*	
Start Date:	9/11/13	Start Qty: 1.00	*1*		Cust Item	ID:							
Required Date:	9/16/13	Req'd Qty: 1.00	*1*		Customer:								
Reference:			•										
Approvals:	Process Pla	n: <u>M</u> (5	Date: 13-09-1	6_ Tooling:	D	ate:			Run	Start	*NI	₹1*	
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*NI	₹2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr											:
D3913	C'	-				ه-ه							
D4020	Α					50							
100		Weld per dwg A/R S.S Large Fab	S. rod Batch: 1248			(EA)	y	1*					
Large Fab		Memo		0.00	(p)	13	.11.	27			37	Sec.	
Large Fab		I- assemble ***inspect	e ribs, weld as per dwg D t before welding mesh***	3913 using DT9610A				,					
			20-1 base mesh and tack vesh to fit if necessary and										:
		3- weld hin ***take lid	nge (3) and Mounting brac I to locate hinge and brack	kets as per dwg D3913 et***		•							11
		4- Weld D	4672-1 blanking plates as	per dwg	·		•						
110		QC9- Inspect visual per	r QSI004- Fusion Welds	0.00									DA
*11 0 *									0	/	3-11-2	9	9
QC		Memo	5.	0.00									9-8
Quality Control					•								

		DQA:	Date:	1
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	2:
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part NCR						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			T		Descri	ption of work order update		nitial	Ad	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							Ì						
Operator													
Material													
Setup													
Other													
Process						T.							
Supplier	_												
Training			1		·								
Unapproved			<u> </u>										
							FAUL	T CATE	GORY				
Land	ing (1			_	General	_	,			٦	_	_
	<u>_</u>	Bending			L	Bend	<u> </u>	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
	<u></u>	Centre N	ot Conce	ntric to	o/s	BOM/Route	<u> </u>	Hardwa			Over/Under	⊢	Temperature/Cure
	ļ	Cracks			L	Broken/Damaged	<u> </u>	4 `	ion Incomplete	<u> </u>	Part Incorre	 	Weld
	<u></u>	Crushed/	'Crimped			Burrs		4	tions Incomplete,	/Unclear	Part Lost/M		Wrong Stock Pulled
	\vdash	Cuffs			-	Contamination	_	-	enance	<u> </u>	Part Moved		
	\vdash	Heat Trea				Countersink		Mislab			Positioned \		-
	L	Inspectio		Tube	<u> </u>	Cut Too Short	\vdash	Misrea	d		Power Loss/	'Surge	Other
	\vdash	Ripples in		-		Drill Holes	_	Offset					
	\vdash	4	Vaves in I		n	Drawing	_	4	Calibration			····	
	Turning Sequence				Finish	\perp	1	Sequence					
i .	1	IM/ave/Tu	vist in Tul	he	1	Folio	1	Outside	Dimensions				

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Basket Base Assemby, 350 Start Qty: 1.00 Req'd Qty: 1.00 Ress Plan:	*1* *1*	Accept	*N900 Cust Item I Customer:		100		Setup Sta	I	S1* S2*
Start Qty: 1.00 Req'd Qty: 1.00 Ress Plan:	*1*	Tooling	Customer:	D:				™ *N	S2*
	Date:	Toolings							
	Date:	_ Tooling: _ SPC (Y/N):		nte:		-	Run Sta Sto	171	R1* R2*
Operation Description QC5- Inspect part comple	eteness to step on W/O	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 9 9-89
Pressure Wash per QSI00	05 4.3	0.00				1			alm 13
	Description QC5- Inspect part comple Memo	Description QC5- Inspect part completeness to step on W/O Memo Pressure Wash per QSI005 4.3	Description Run Hours QC5- Inspect part completeness to step on W/O Memo 0.00 Pressure Wash per QS1005 4.3 0.00	Description QC5- Inspect part completeness to step on W/O Memo 0.00 Pressure Wash per QSI005 4.3 0.00	Description QC5- Inspect part completeness to step on W/O Memo 0.00 Pressure Wash per QSI005 4.3 0.00	Description QC5- Inspect part completeness to step on W/O Memo 0.00 Pressure Wash per QSI005 4.3 0.00	Description QC5- Inspect part completeness to step on W/O Memo O.00 Pressure Wash per QSI005 4.3 O.00	Description QC5- Inspect part completeness to step on W/O Memo Run Hours 0.00 Code Qty Qty 0.00 Pressure Wash per QSI005 4.3 0.00	Description QC5- Inspect part completeness to step on W/O Memo Run Hours 0.00 B-\l-29 Pressure Wash per QS1005 4.3 0.00

									DQA:	Date	e:
NCR: Y	es / No				WORK ORDER NON-	CONFOR	RMANCE / UP	DATE			
-					r				QA Closed:	Date	9:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
	``				Rework	1 	Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	ο.				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	The	rmoforming	Finishing	-1	re/Packaging	Other
NCR N	o				Work Order Update]	Large Fab	Composite]	Supplier	
			1								
Root					ption of work order update	Initial	1	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector
Doc/Data	_										
Equip/Tooling	_										
Operator	_										
Material	4										
Setup	_								1		
Other	_										
Process	_										
Supplier	_		1								
Training											
Unapproved			<u> </u>	İ							
						AULT CAT	EGORY				
Landin	g Gear			_	General				1	r	
1	Bendin	-		_	Bend	Grain			Ovalized		Pressure/Forced
	-	Not Conce	ntric to	o/s	BOM/Route	Hardy		<u> </u>	Over/Under	 -	Temperature/Cure
<u> </u>	Cracks			_	Broken/Damaged	\mathbf{H}	ction incomplete	_	Part Incorre) -	Weld
ļ		d/Crimped			Burrs	Instru	ctions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs			_	Contamination	Main	tenance		Part Moved		
	Heat T	eat			Countersink	Misla	beled		Positioned V	· -	
l	Inspec	ion Strip ir	Tube		Cut Too Short	Misre	ad		Power Loss/	'Surge	Other
	Ripples	in Bend			Drill Holes	Offse	t				
	Torque	Waves in	Extrusio	n 📗	Drawing	Out o	f Calibration				
	Turning Sequence Finish Out of Sequence										

Outside Dimensions

Wave/Twist in Tube

Work Ord September-11-1				*106	3737*						Page 3
Item ID: Revision ID:	D3913-041			Accept	*N900	040 ′	100)* s	etup Sta	1 7	S1*
Item Name:	Long Basket	Base Assemby, 350							Sto	^p *N.	S2*
Start Date:	9/11/13	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date	: 9/16/13	Req'd Qty: 1.00	*1*		Customer:						
Reference:			-	× .							• }
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ite:		R	tun Sta	1/1	R1*
	QC:		Date:	SPC (Y/N):	Da	ıte:			Sto	*N	R2*
Sequence ID/ Work Center I	D	Operation Description White Gloss(Ref. 4.3.5.2)) per OSI005 4.3-Steel	Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130			mon orm	ge RALDOUS)			1		<i>Ø</i>	_AS
Powder Coating SW24		Memo		of hinge (3) prior to powd	or.				·	,	13-12-5
rowder spaints	1	coat	s and mask only interio	of fininge (3) prior to powd	Primer:	10/9	77				
Meson	proces	1ST COAT:									
		START TIM OVEN TEM FINISH TIM	1PERATURE:/	<u>/</u>	Paint	: 12767	74				
	ſ	*******	******** 2nd coat if	necessary**********	*****						•
ee LL by	etorep	2ND COAT START TIM OVEN TEM FINISH TIM	1/e: (PERATURE:	3rd 1f	necessony						
40/145		QC3- Inspect Part Finish	,	0.00							
1 <u>/</u> 10								1			m/1/12/12/12
QC		Memo		0.00							14.4 11016 OB
Quality Control											

									DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-C	CONFORI	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.	•				Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR No	•				Use-as-is Work Order Update	Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	tion of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspect
Doc/Data											

QC Inspector

Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Ovalized Grain Pressure/Forced Bending BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Out of Sequence Finish

Outside Dimensions

Wave/Twist in Tube

Folio

Equip/Tooling Operator Material Setup

Work Orde September-11-1.				*1067					Page 4			
Item ID: Revision ID:	D3913-04	1		Accept	N900	040	100)*	Setup	Start	*N:	S1*
Item Name:	Long Baske	et Base Assemby, 350								Stop	*N:	S2*
Start Date: Required Date: Reference:	9/11/13 9/16/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:							
Approvals:	Process I	Plan:	Date:	Tooling:	Da	ate:			Run	Start	*N	R1*
	QC:		Date:	_ SPC (Y/N):	Date:					Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	# Plan Code	Accep Qty	t Ro	•	Reject Number	Insp. Stamp
*150 *150* HandFinish HandFinishing		Assemble as per dwg Memo Pick Kit		0.00				1,	<u> </u>		<u> </u>	17/11
*160 *160*		QC5- Inspect part compl	eteness to step on W/O	0.00 Shi	.							
Quality Control		Мето		0.00	,						.5	:

Identify as per dwg & Stock Location: W 6

Memo

0.00 D4030-043/13106739 1x / Il 13/106

170 Packaging

Packaging

											DQA:	Dat	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C	COI	NFOR	MANCE / UPDATE					
											QA Closed:	Dat	e:	
Work Ord	or.					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
WORK OIL	٠					Rework	1		Skid-tube Crosstub	-	1	Water Jet	\neg	Engineering
Part I	No.					Scrap	1		Machining Small Fa		Pro	d. Eng. Coor.	-	Quality
	•					Use-as-is	1	•	noforming Finishin	_	4	re/Packaging	ヿ	Other
NCR I	No.					Work Order Update			Large Fab Composit	e		Supplier		
Root						ption of work order update	1	Initial	Action		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	<u> </u>	QC Inspector
Doc/Data	Ш													
Equip/Tooling	Щ	•					İ							
Operator	Ш													
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11	·					······································	AUI	LT CATE	GUKY					
Landi	ing (1				General] _{C==} :=			Ovalized	ſ		D
	\vdash	Bending	- .	-4-:-4-	o/s	Bend BOM/Bouts	\vdash	Grain		-	4	*-1	_	Pressure/Forced
	\vdash	Centre No	or Concer	icric to	U/3	BOM/Route	\vdash	Hardwa		-	Over/Under	ŀ	\neg	Temperature/Cure
	\vdash	Cracks	Cuiusas - J		ļ	Broken/Damaged	\vdash	- 1 `	ion Incomplete	\vdash	Part Incorred	· · · · · · · · · · · · · · · · · · ·		Weld
	-	Crushed/	crimped		\vdash	Burrs	-	4	tions Incomplete/Unclear	\vdash	Part Lost/Mi	ssing		Wrong Stock Pulled
	\vdash	Cuffs Heat Trea			-	Countersink	-	Mainte		\vdash	Part Moved	Vrong		
		IHPAT I <i>T</i> P2	भा			I OUGHEISINK		HVIISIANE	PIEC		TPOSITIONED V	vrnng		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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Work Ord September-11-				*106	3737*							Page 5
Item ID: Revision ID: Item Name:	D3913-041 Long Basket	Base Assemby, 350		Accept	*N9000	14N	100)* 5	Setup	Start Stop		S1*
Start Date: Required Date Reference:	9/11/13 e: 9/16/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:							
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):	Date:			I	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stainp

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

180

120

Quality Control

NCR:	Yes /	No	WORK

OPDED NON-CONFORMANCE / LIDDATE

DQA: _____ Date: _____

NCR. 1	es /	NO				WORK ORDER NON-	COI	4rONI	MANUE / OF	DAIL	QA Closed:	Date	1
Work Orde	ŕ:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N						Rework Scrap		ľ	Skid-tube Nachining	Crosstube Small Fab	-1	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Descr	ription of work order update	T	nitial	Ac	tion	Sign &		
Cause	D	ate	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup other rocess upplier raining napproved													
							FAUL	T CATE	GURY		<u> </u>	-	
Landir	Cer Cra Cru Cuf Hea Insp Rip	nding otre Not other oth	: Strip in	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions Incomplete/ nance led	'Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
- 1	lsa/a	wo/Twi	ct in Tub		1	Folio	1	Louteide	Dimensions				

Work Order ID: Parent Item:

106737

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Start Date: 9/11/13

Required Date: 9/16/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

IPP Rev:B chg qty's DD 10.04.12

IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC

REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of ' Measure	Qty on Hand	Qty per Kit	Otv	Qty Issued OA S	Date Issued	Status
D3913-1 Rib	1880 A	Manufactured	No			100	Each	2.0000	1	1 (24 2.89	3./	1.3
·				Location		Loc Qty	<u>L</u> c	oc Code	31	0361	7->	<u>—(I</u>) .
				WA 979	70	1							
				WA005	19	1					TAG		
i.				886	37	1					24		:
391 <mark>3-3</mark> Lib		Manufactured	No			100	Each	3.0000	1				27
				Location		Loc Qty	<u>L</u> c	oc Code		3	1075	319 -	->-
1				WA004		1							
				100	442	1							
				WA005 691	۷0	2							. [
				846		1					DAS		
03913-7		Manufactured	No			100	Each	12.0000	2	2	24	3·//·a	7_
i i				Location		Loc Qty	<u>L</u> a	oc Code		\mathfrak{F}	107=	354	
				WA004		11					-	•	
				100		4							
				101 997		4							
				WA006	01	1							
•				100	482	1							

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NCR: Y	es /	No				WORK ORDER NON-O	O	NFORM	MANCE / UP	DATE	QA Closed:	Date	e:
Work Orde	r.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part N NCR N	lo					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining Moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			<i>Y</i>				A.5.5	LT CATE	CORV				
Landin	ng Go:					General	AUL	LICATE	JURY				-
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misreac Offset	on Incomplete ions Incomplete/ nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
i l	110	rque W	aves in b	:xtrusior	'	Drawing	1	Jour or C	alibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

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September-11-13 11:35:05 AM

Work Order ID:	106737 D3913-041					Start	Date: 9/11/13	Required Date: 9/16/13
Parent Item Name:	Long Basket Base Assemby, 350						t Qty: 1.00	Required Qty: 1.00
D3913-9 Hinge Rib	Manufactured	No		100	Each	4.0000	1	13.11.27
			Location	Loc Oty		Loc Code	3	100305(1)
			WA004	3				
			102353	3				
• •			WA005	1				- (-
1			70138	1				_ (D AC
D3916-5 Light Rib	Manufactured	No		100	Each	19.0000	3	3/3-11.22
			Location	Loc Oty		Loc Code	\Rightarrow	07318
			WA004	3				_
			104316	1			- <u>-</u>	
			94698	2				_
			WA005	16				
			103589	6				<u> </u>
			103590	5				<u> </u>
			77142	1				$-\lambda \Omega \Delta \gamma$
			82933	4		•	·	- (24 , -
D3916-041	Manufactured	No		100	Each	4.0000	2	2 289 /3.//.2
Rib Assembly			Location	Loc Qty		Loc Code		3107241->
			WA004	2				7101011
			WA004 104996	2			-	-
			WA005	2				
			WA005 81444	2				
			01444	2				

											[DQA:	Da	te:	1
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE					
											QA Clo	osed:	Da	te:	
Work Orde	or.					DISPOSITION				AGAINST D	EPARTN	/IENT	/PROCESS		
Work Ord	٠					Rework	٦		Skid-tube	Crosstube	7		Water Jet		Engineering
Part,i	VΩ					Scrap		ľ	Machining	Small Fab	┪	Pro	d. Eng. Coor.	-	Quality
, ,,,	•••					Use-as-is	1		noforming	Finishing	Rec		re/Packaging	-	Other
NCR I	No.		,			Work Order Update	1		Large Fab	Composite	1	•	Supplier	-	\Box
				•			_								
Root					Descri	ption of work order update	1	Initial	Ac	tion	Sign	&			
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Desc	ription	. Da	te	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling															
Operator			•												
Material									•		İ		1		
Setup							ł								
Other															
Process							1								
Supplier															
Training															
Unapproved	П														
						F	AU	LT CATE	GORY				_		
Landi	ng (Sear				General		_			_		•	_	
		Bending	•			Bend		Grain			Ovalize	ed			Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		_Over/t	Jnder	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part In	corre	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lo	ost/M	issing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-11-13 11:35:06 AM

Work Order ID: 106737 Required Date: 9/16/13 Parent Item: D3913-041 **Start Date: 9/11/13** Long Basket Base Assemby, 350 Start Qty: 1.00 Required Qty: 1.00 Parent Item Name: D4017-7 No 100 Each 10.0000 Manufactured Loc Oty Loc Code Location WA004 94821 WA005 69730 82969 85435 88392 B107394 D4017-9 100 9.0000 No Each Manufactured Location Loc Qty Loc Code WA005 100536 70341 81445 ₹D4034-041 100 Each 4.0000 No Manufactured Aft Upper Rib Assembly Loc Code Location Loc Qty WA004 103357 WA005 84048 B105994-100 5.0000 D4034-043 Each Manufactured No Fwd Upper Rib Assembly Location Loc Qty Loc Code WA 103421 WA004 103353 WA005 103355 82980 Page 3 September-11-13 11:35:06 AM Shop Packet Print

											DQA:	Dat	e: ,	.
NCR: Y	es / N	lo				WORK ORDER NON-	CON	FORN	MANCE / UPDATE		QA Closed:	 Dat	e:	
Work Orde	ř.	•				DISPOSITION			AGAIN:	ST DE	PARTMENT,	/PROCESS		
Part N	o	*				Rework Scrap Use-as-is Work Order Update		N Therm	Skid-tube Crosstul Machining Small Fa noforming Finishin Large Fab Composi	ab ng	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineerin Qualit Othe	у
Root Cause	Dat	:e	Step	Qty		iption of work order update or Non-conformance		nitial ef Eng	Action Description		Sign & Date	Verification	QC Inspe	ector
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved		,												
				· · · · · · · · · · · · · · · · · ·			FAULT	CATE	GORY		•	•		
Landin	g Gear				,	General	AULI	CAIL						
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instructi Mainte Mislabe Misread Offset Out of C	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing [Pressure/Ford Temperature, Weld Wrong Stock Other	/Cure
į	Liurni	u8 26	quence		1	JEHHSH	-1 19	out of 5	equence					

Outside Dimensions

Wave/Twist in Tube

September-11-13 11:35:06 AM

Work Order ID:	106737							
Parent Item:	D3913-041					Start D	ate: 9/11/13	Required Date: 9/16/13
Parent Item Name:	Long Basket Base Assemby, 350					Start (Qty: 1.00	Required Qty: 1.00
D2581	Manufactured	No		100	Each	113.0000	2	2 (13.11.2)
Mounting Bracket			w ,*	1 0+-			* ***	3107768-20
			Location	Loc Qty		Loc Code		DIO / / 68
			WA004	113				<u> </u>
			103076 103952	24 27				
			103932	48				
			70766	2				
			81253	1				· <u>·······</u>
			82506	2			-	 ,
			83230	3				
			85452	2				
			87706	2				
			99837	2				- <i>1</i>
D2931	Manufactured	No		150	Each	2,128.0000	2	2 (-13.11.27
Bumper							c	13/12/
			Location	Loc Oty		Loc Code		e e
			GA ·	130				
			46064)	130				<u> </u>
			ST021	1998				
			86435	1998				
D3913-15	Manufactured	No		100	Each	10.0000	1	1
Wide Handle Plate								1 Cp(13.11.27
			Location	Loc Qty		Loc Code		3107769-X
			WA004	10				
			104675	5				
			97719	5				
D4016-1	Manufactured	No		100	Each	51.0000	3	- (DAS 3 (24) (P(13-11-27)
Hinge Half, Base	Wininington va							· CP C 13 11.2/1
11gv,			Location	Loc Qty		Loc Code	,	3107938(3)
			WA004	51				
			103414	31				<u> </u>
			104200	20				

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE			
											QA Closed:	Date	:
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	. No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
_		<u> </u>							-	•	- 1 c: o	T	
Root		Data	Char			ption of work order update	- 1	Initial		tion	Sign &	Verification	OC Increases
Cause Doc/Data		Date	Step	Qty		or Non-conformance	- Cr	nief Eng	Desc	ription	Date	verification	QC Inspector
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<u> </u>		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to C)/S	BOM/Route	L	Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	L	-	on Incomplete		Part Incorre	ct	Weld
		Crushed/	'Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte	nance	ļ	Part Moved		
	\Box	Heat Tre	at		<u> </u>	Countersink	L	Mislabe	eled		Positioned V	Vrong	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
	1	Ripples in	n Bend			Drill Holes		Offset		-			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-11-13 11:35:06 AM

Work Order ID: 106737 Parent Item: D3913-041 **Start Date: 9/11/13** Required Date: 9/16/13 Start Qty: 1.00 Long Basket Base Assemby, 350 Required Qty: 1.00 Parent Item Name: D4021-1 No 100 Each 58.0000 Manufactured Handle Plate Loc Qty Loc Code Location WA004 58 100366 100649 103509 28 15 105883 3 94596 DAS D4021-5 100 Each 39.0000 Manufactured No 26 Blanking Plate Location Loc Qty Loc Code ST084 39 103399 32 103829 85065 D4020-11 End Mesh, Basket 100 Each 3.0000 No Manufactured 3100331 Location Loc Qty Loc Code WA007 81442 84972 D4672-1 100 16.0000 No Each Manufactured Blanking Plate Loc Qty Loc Code Location WA004 12 101186 2 10 105887 WA005 88253

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NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	MANCE / UP	PDATE		•			
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WOIK OIG	-			<u>-</u>	****	Rework	7		Skid-tube	Crosstube	٦		Water Jet		Engineering
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ŊCR I	No.	4				Work Order Update	1		Large Fab	Composite	1	·	Supplier	-	
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 	oxed	Bending									┥.	Ovalized		L	Pressure/Forced
		Centre No	ot Conce	ntric to (o/s	BOM/Route	\perp	Hardwa	re		_ (Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete		ال	Part Incorred	ct c	L	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete,	/Unclear	_][Part Lost/Mi	ssing		Wrong Stock Pulled
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		Heat Trea	at			Countersink		Mislabe	eled		_]r	Positioned V	Vrong		_
	Г	Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		7	Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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September-11-13 11:35:07 AM

Work Order ID:	106737												
Parent Item:	D3913-041							Start D	ate: 9/11/13	3	Required Date: 9/1	6/13	
Parent Item Name:	Long Basket Base	Assemby, 350						Start (Qty: 1.00		Required Qty: 1.0	0	
M304EX0.75-16F Expanded Metal Flat SS	:	Purchased	No			100	sf	1,242.3742	33	33	(24 24	13	-11-27
Expanded Wetal Flat 55	•			Location	<u>1</u>	Loc Qty		Loc Code	m	127	403;	33	\supset
				MAT		176.2791180							
					125113	176.279118							
				WA		209							
					125457	209							
	•			WA007		857.0950797							
					123448	10.96							
					125457	4.691526		•					
					125605	480					!		
					M126052	90.02608							
					M126134	108.417474							
					M126500	163							DAS
MS20600-AD4W3 Cherry Rivets		Purchased	Ņo			150	Each	735.0000	2	2	mp74-	H6_	26 9-89
				Location	<u>n</u>	Loc Qty		Loc Code			13-12-	(0	
				ST311		602					13-10	Q.	
					122151	4							
					122452	4							
					123525	288							
					124231	306							
				WA003		133							
					107939	133							

											DQA:	Date	:: <u> </u>
NCR:	Yes	/ No				WORK ORDER NON-	CON	NFORN	MANCE / UP	DATE	QA Closed:	Date	3.
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Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	-					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1		oforming	Finishing	Rec/Sto	re/Packaging	Other
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Root	ł				-	ption of work order update		Initial	Act		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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	-	Heat Trea	at		<u> </u>	Countersink	\vdash	Mislabe			Positioned \		
		1.1000 1100	ut		<u> </u>	1000	-	4		—	-		 1
1		Inspectio	n Strip in	Tube		Cut Too Short	1	Misread		į	Power Loss,	/Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

September-11-13 11:35:07 AM

Work Order ID:	106737										
Parent Item:	D3913-041						Start D	Date: 9/11/13		Required Date: 9/16/	/13
Parent Item Name:	Long Basket Base Assemby, 350						Start (Qty: 1.00		Required Qty: 1.00	
MS21042L3 Nut	Purchased	No			150	Each	6,501.0000	6	6	M at the state of	DAS 26 9-89
		<u>I</u>	Location	<u>.</u>	Loc Oty		Loc Code				26
			FP001		3						9-09
				122141	3						
		(GA		18						
				122452	18						
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				123265 M126036	43 56						
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				M126333	4000				6X	•	
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		<u> </u>	Location	<u>1</u>	Loc Oty		Loc Code		ſ		9-89
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				122063	182						
		9	ST294		158						
				122063	158						
		S	ST295		3						
··				123352	3						
		S	st510		3695			E	2/21		
			•	123900	3695			1			
		ç	ST510a		5000						
				125646	5000						
					3.5.5.					,	

										DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-C	10:	NFORM	MANCE / UP		QA Closed:	Date:	
Work Order:	:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR No)				Use-as-is Work Order Update]	Thern	noforming Large Fab	Finishing Composite	Rec/Stol	re/Packaging Supplier	Other
Root				Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process												

Landing Gear General Ovalized Pressure/Forced Bend Grain Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Instructions Incomplete/Unclear Wrong Stock Pulled Crushed/Crimped Burrs Part Lost/Missing Part Moved Cuffs Contamination Maintenance Mislabeled Positioned Wrong Heat Treat Countersink Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Finish Out of Sequence Turning Sequence Folio Outside Dimensions

FAULT CATEGORY

Wave/Twist in Tube

Supplier Training Unapproved

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Page 8

Work Order ID	:
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106737

Parent Item:

AN3-10A

AN960JD8

Bolt

D3913-041

NAS1149DN832J

Parent Item Name:

Long Basket Base Assemby, 350

Purchased

Purchased

No

150

Each

Start Date: 9/11/13

Required Date: 9/16/13

Start Qty: 1.00

Required Qty: 1.00

DAS 371.0000 6 **26** 9-89

	Location	<u>1</u>	Loc Qty		Loc Code	
	ST351		14			_
		124221	3			_
		124858	11			_
	ST513		357			_
		m125709	357			_
No			150	Each	0.0000	2

13-12-63.19 13-12-60.

DAS 26 9-89

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Work Orde	or.					DISPOSITION	AGAINST DEPARTMENT/PROCESS							
WOIK OIL	٠			**		Rework			Skid-tube	Crosstube	1	Water Jet	\neg	Engineering
Part I	۷n					Scrap		Machining Small Fab		Prod. Eng. Coor.			Quality	
1 0111	10.					· H I		noforming	~ <u></u>		Rec/Store/Packaging		Other	
NCR I	No.					Work Order Update	1		Large Fab	Composite	1	Supplier	\dashv	H
	•						-		, n		1	[
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	1	QC Inspector
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	Bending				Bend		Grain			Ovalized	1		ressure/Forced	
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	Cracks				<u> </u>	Broken/Damaged		Inspection Incomplete			Part Incorre	, , , , , , , , , , , , , , , , , , ,		Veld
	<u></u>	Crushed/	Crimped		L	Burrs		4	ions Incomplete/	Unclear	Part Lost/M	- L	\v	Vrong Stock Pulled
	L	Cuffs			<u> </u>	Contamination		Maintenance			Part Moved			
		Heat Tre				Countersink		Mislabe			Positioned V	· · ·		
	\vdash	Inspection	n Strip in	Tube	<u> </u>	Cut Too Short		Misread	I		Power Loss/	'Surge	C	Other
1	Ripples in Bend				Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

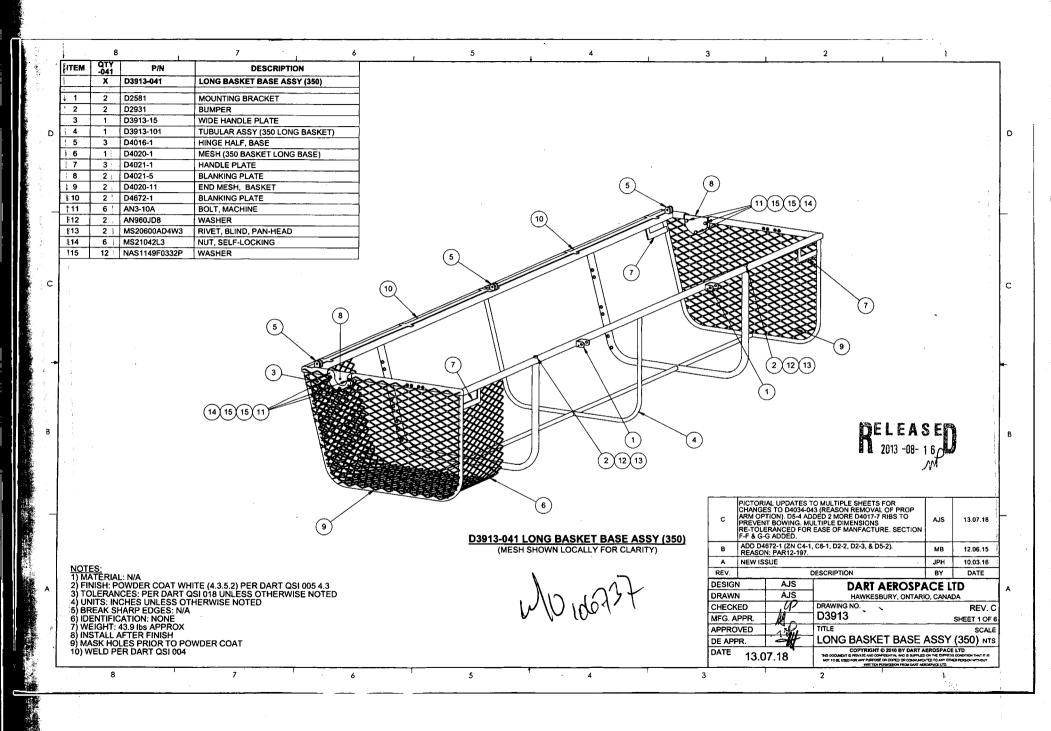
Wave/Twist in Tube

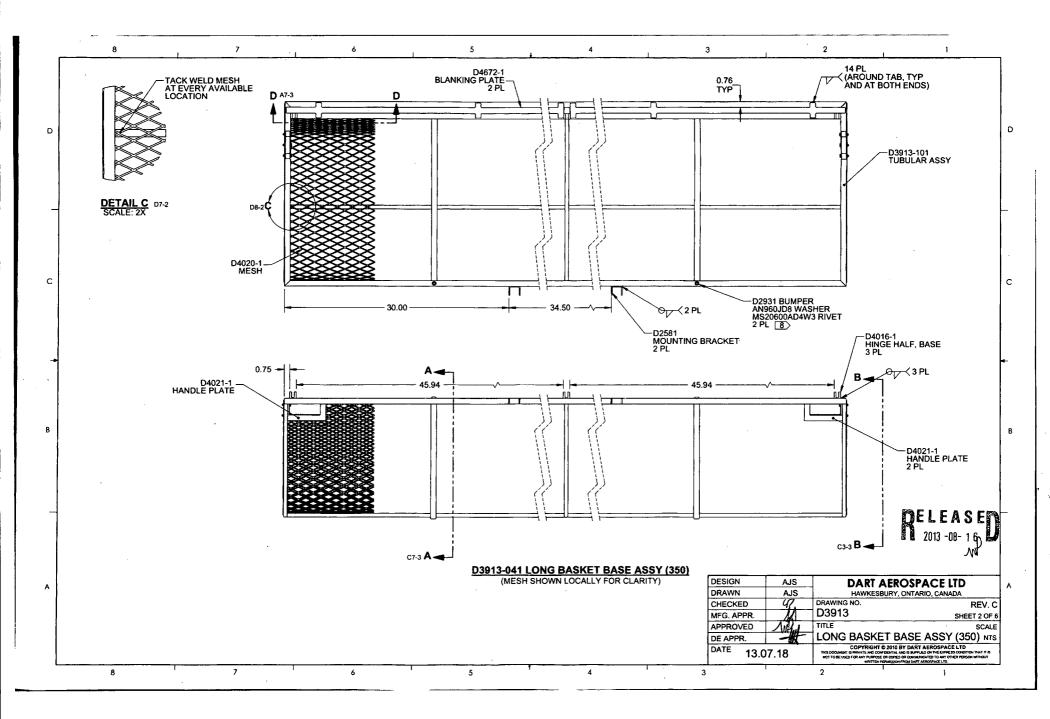
Torque Waves in Extrusion

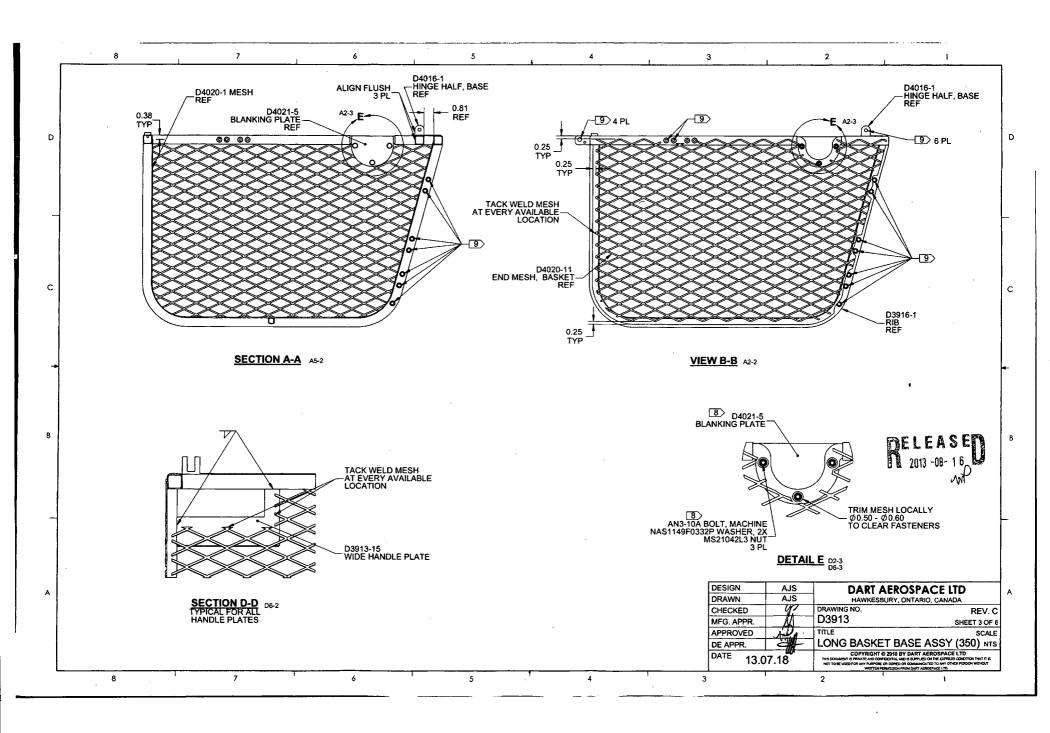
Drawing

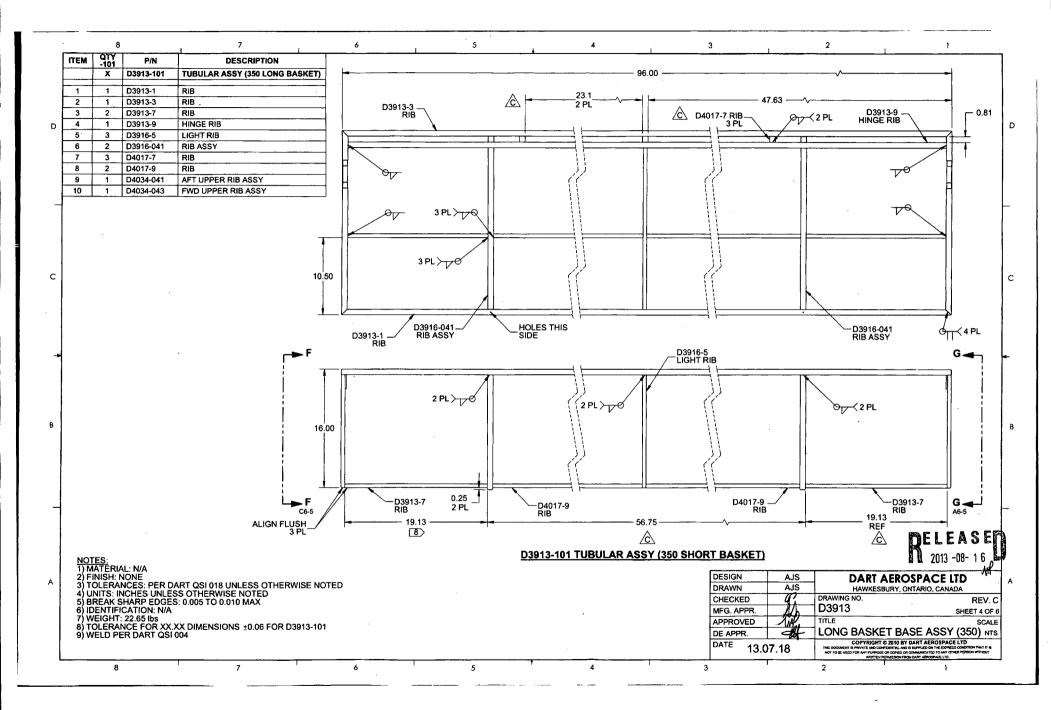
Finish

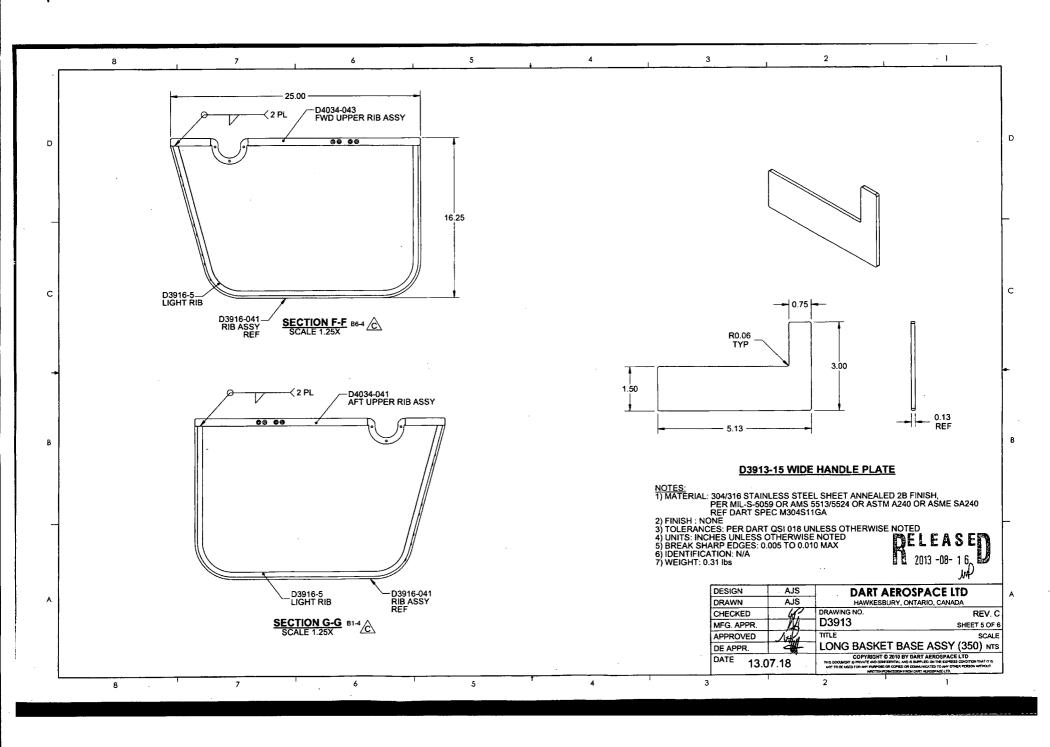
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